

Date: Tuesday, 20/01/2009 2:32:07 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD UPPER MOUNT
 Job Number : 44961
 Estimate Number : 13747
 P.O. Number :
 This Issue : 20/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38705
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3870 PRELIM
 Previous Run : Drawing Revision : PRELIM
 Material :
 Due Date : 27/01/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 09-01-20 as per prelim issue DD verified by:ec

POSITIVE
RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X04000 250 x 4.00 6061-T6 Bar .250 x 4.00



Comment: Qty.: 0.2039 f(s)/Unit Total: 0.8156 f(s)
 6061-T6 Bar .250 x 4.00
 batch: 109025 HB 9-1-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3870
 Dwg Rev: PRE
 Prog Rev: Lim HB 9-1-21

6

2-Deburr edges and holes if necessary HB 9-1-21

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 9-1-21

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEER IN
APPROVAL

09-01-21

87

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

09-01-27

X5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:32:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD UPPER MOUNT

Job Number: 44961

Part Number: D38705

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

For 09/01/27 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock

Location: PPP44964

SS 09/01/28 (K6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



MF 09-01-28

POSITIVE RECALL

EFFECTIVE 09/01/21 AUTH

RELEASED DATE 09/02/17

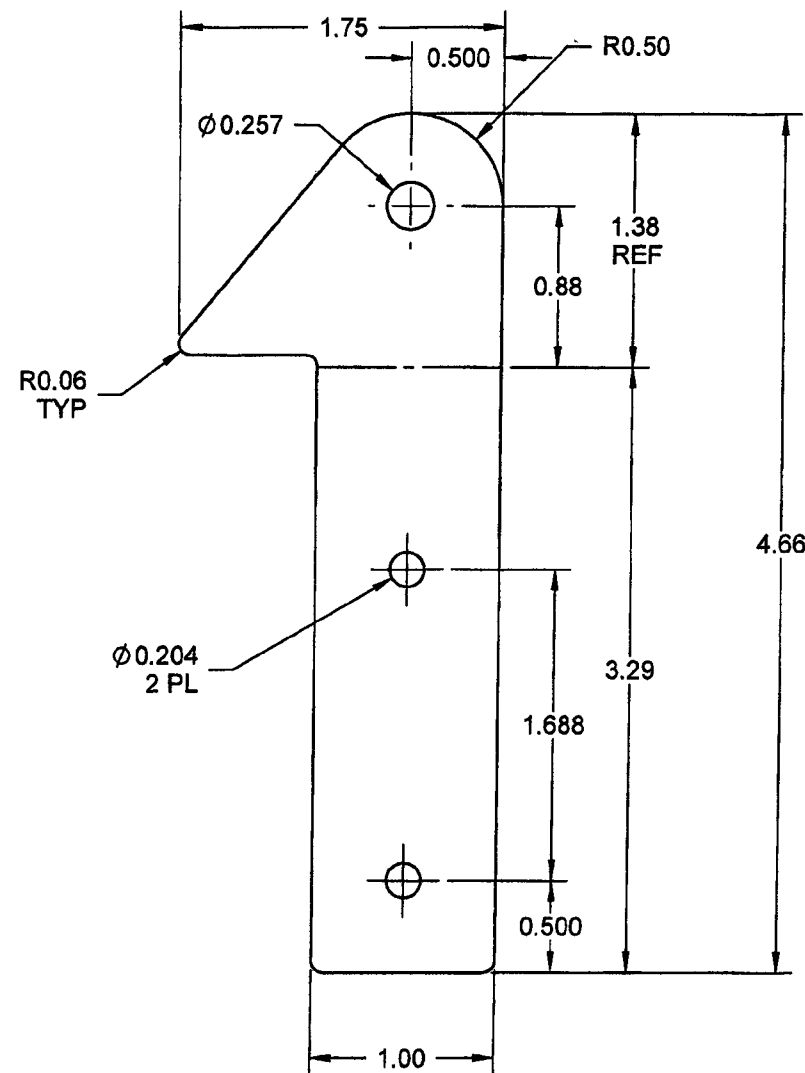
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

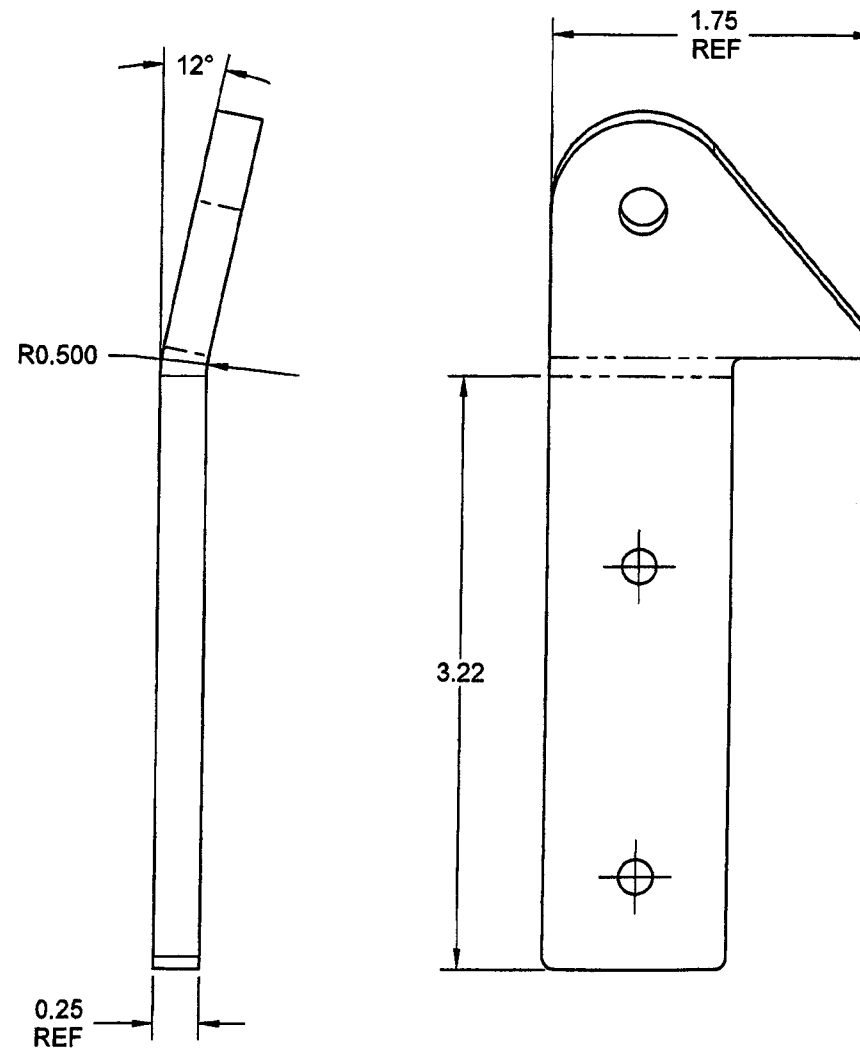
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

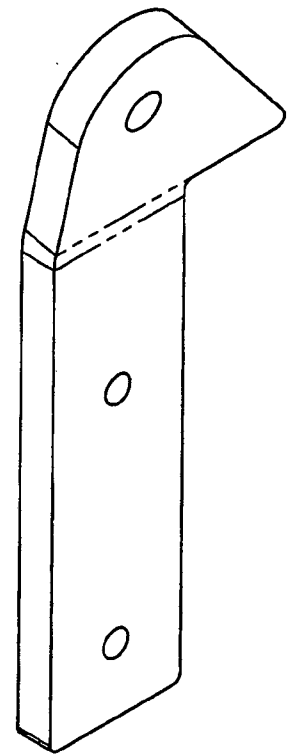
NOTE: Date & initial all entries



D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



**D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F**

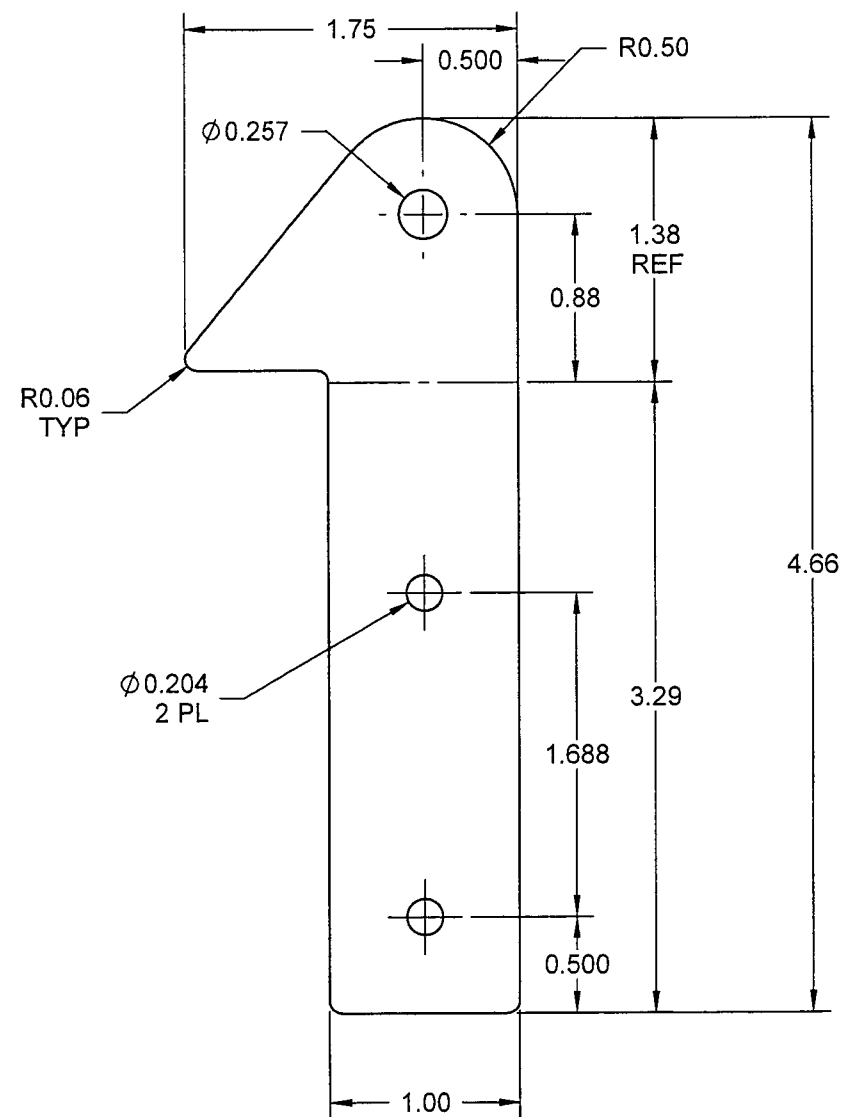


NOTES:

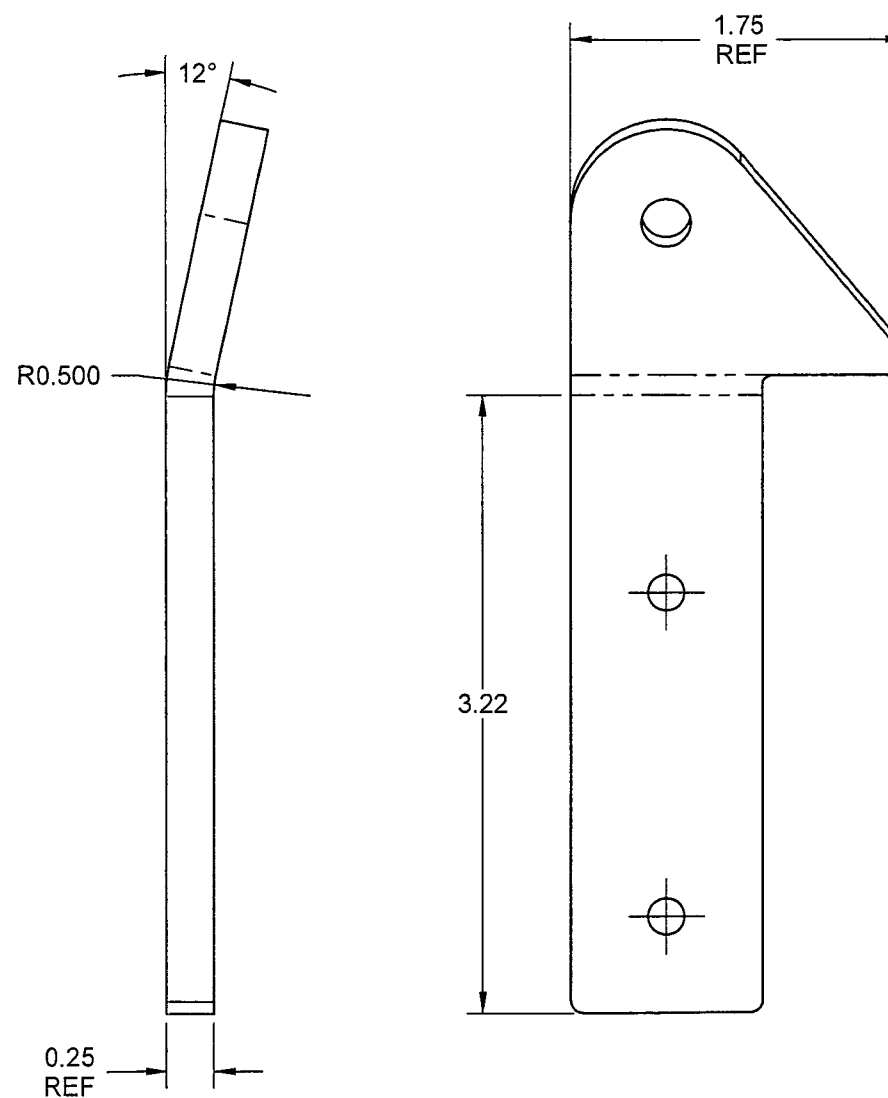
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.12.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

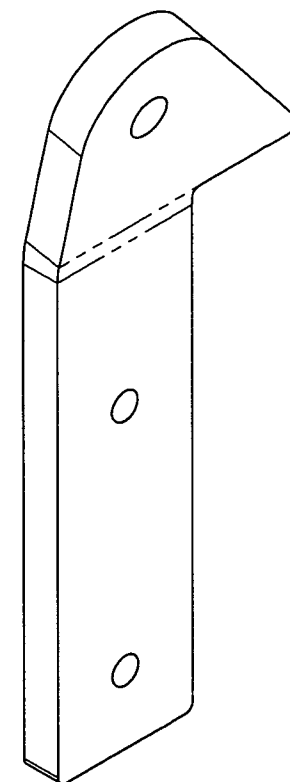
PRELIMINARY ISSUE
29/01/15
44961



D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F









44961

RELEASED
10/06/2011

NOTES:

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